



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D5350-043
Job Sheet 183681



Part No: D5350-043

Job Qty: 2 ea

Part Name: Aft Beam Assembly



Part Weight: 0 lbs

Job Created: 9/24/18

Due Date: 10/5/18

Type: SOLD

Status: Scheduled

Job Tracking No: SIOP

Created By: Marie Lajeunesse

Description:

Priority: Medium

Note: DWG REV D SHEET 2 IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP REV:B 16.01.25 rev.a dwg DD
VERF:JLM IPP REV:C 16.06.30 DWG REV.B DD VERF:JLM IPP REV:D 17.01.09 DWG REV.c DD VERF:JLM
IPP REV:E DWG. REV.D 17/04/11 JFS VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		10/5/18	0.00	0.00	Start Up Machining-4		llm
100	Bandsaw	2 pcs		10/5/18	0.00	4.65	Bandsaw1		llm
110	CNC Vertical Machining	2 pcs		10/5/18	0.42	11.76	HAAS1-2		!!
120	QC	2 pcs		10/5/18	0.00	0.00	QC2 Machining-4		ll
130	Mill Conv	2 pcs		10/5/18	0.00	11.55	Mill Conv 1		ll
140	QC	2 pcs		10/5/18	0.00	0.00	QC8		may 18/10/21
150	Skidtubes	2 pcs		10/5/18	0.00	0.64	Skidtubes-3		DAS
160	QC	2 pcs		10/5/18	0.00	0.00	QC5		OCT 30 2018 68
170	HandFinish	2 pcs		10/5/18	0.00	0.68	HandFinish1		DE 18/10/31-89
180	QC	2 pcs		10/5/18	0.00	0.00	QC7-5		DE 18-10-31
190	Powdercoat	2 pcs		10/5/18	0.00	1.16	Powdercoat1		DE 18-10-31
200	QC	2 pcs		10/5/18	0.00	0.00	QC3		DE
210	Small Fab	2 pcs		10/5/18	0.00	0.69	Small Fab-9		DAS
220	QC	2 pcs		10/5/18	0.00	0.00	QC5		NOV 22 2018 68
230	Packaging	2 pcs		10/5/18	0.00	0.00	Packaging3-2		NOV 22 2018 9-89
240	QC21-SA	2 Ea		10/5/18	0.00	0.00	QC21		DAS 21 NOV 22 2018 9-89

M 135951

START: 2:15

CV.T: 300 FINISH: 2:45

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	11.1400 ft (5.57 ea)	90-Start up Operation	
CBL-1240	Cable	10.8400 ft (5.42 ea)	210-Small Fab	5032661
CBL-460	Loop Sleeve	20 Ea (10 ea)	210-Small Fab	5119332
D5346-3	Bushing	8 Ea (4 ea)	210-Small Fab	5107082
D5350-5	Adapter	2 Ea (1 ea)	210-Small Fab	5018062
MS17984-C412	Pin, Quick Release	4 Ea (2 ea)	210-Small Fab	5043972
MS17984-C418	Quick Release Pin	2 pcs (1 ea)	210-Small Fab	5036480
MS17984-C517	Pin, Quick Release	4 Ea (2 ea)	210-Small Fab	5000375

S090372 2x

S115941 1x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

90-Start up Operation
210-Small Fab

M6061T6B1.000X06.000
CBL-1240
CBL-460
D5346-3
D5350-5
MS17984-C412
MS17984-C418
MS17984-C517

11	46	0
11	187	0
20	179	0
8	17	0
2	11	0
4	15	0
2	29	0
4	38	0

Part Specifications

Specifications could not be found.

Plex 9/24/18 2:56 PM Dart.lajeunesse.marie



Container No: S119704

Part: D5350-043

Job No: 183681

Serial No/Batch: S119704

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/18/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

DART AEROSPACE LTD		Work Order:	183681
Description: Aft Beam		Part Number:	D5350-3
Inspection Dwg: D5350	Rev: D	Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	.258 Ø	✓		Ping gauge	
0.80	+/-0.030	.803	✓		Vernier	
1.00	+/-0.030	1.003	✓		Vernier	
1.60	+/-0.030	1.600	✓		Vernier	
2.12	+/-0.030	2.122	✓		Vernier	
0.65	+/-0.030	.650	✓		Vernier	
3.15	+/-0.030	3.149	✓		Vernier	
33.10	+/-0.030	33.10	✓		Tape	
35.60	+/-0.030	33.60	✓		Tape	
0.55	+/-0.030	.551	✓		Vernier	
0.280	+0.015/-0.005	.278	✓		high gage	
12.000	+/-0.010	11.999	✓		Vernier	
0.62	+/-0.030	.619	✓		Vernier	
5.42	+/-0.030	5.423	✓		high gage	
4.25	+/-0.030	4.254	✓		high gage	
0.30	+/-0.030	.300	✓		Vernier	
0.35	+/-0.030	.352	✓		Vernier	
2.50	+/-0.030	2.500	✓		Vernier	
0.70	+/-0.020	.705	✓		Vernier	
1.50	+/-0.030	1.501	✓		Vernier	
1.00	+/-0.030	1.006	✓		Vernier	
0.550	+/-0.010	.558	✓		Vernier	
0.225	+/-0.010	.224/.225	✓		Vernier	
0.045 x 45°	+/-0.010 x +/-0.5°	.050/45°	✓		Vernier	
2.05	+0.030/-0.010	2.049	✓		high gage	
1.030	+0.015/-0.000	1.030	✓		Vernier	
0.250	+0.015/-0.010	.251	✓		Vernier	
Ø0.375	+0.0004/-0.0010	.374 Ø	✓		Ping gauge	
Ø0.415 x 90°	+/-0.010 x +/-0.5°	.420 90°	✓		Vernier	
3.88	+/-0.030	3.881	✓		Vernier	
0.30	+/-0.030	.295	✓		Vernier	
0.35	+/-0.030	.344	✓		Vernier	
0.20	+0.030/-0.010	.199	✓		Vernier	
0.40	+/-0.030	.393	✓		Vernier	
0.45	+/-0.030	.441	✓		Vernier	
0.55	+/-0.030	.544	✓		Vernier	
0.65	+/-0.030	.640	✓		Vernier	
0.30	+/-0.030	.297	✓		Vernier	
0.30	+/-0.030	.297	✓		Vernier	

DART AEROSPACE LTD		Work Order:	183681
Description: Aft Beam		Part Number:	D5350-3
Inspection Dwg: D5350	Rev: D	Page 2 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	+/-0.030	3.002	✓		Vernier	
64.73	+/-0.030	64.740	✓		Tape	
0.25	+/-0.030	.248	✓		Vernier	
2.70	+/-0.030	2.702	✓		Vernier	
2.40	+/-0.030	2.401	✓		Vernier	
R0.25	+/-0.030	R.250	✓		Gage	

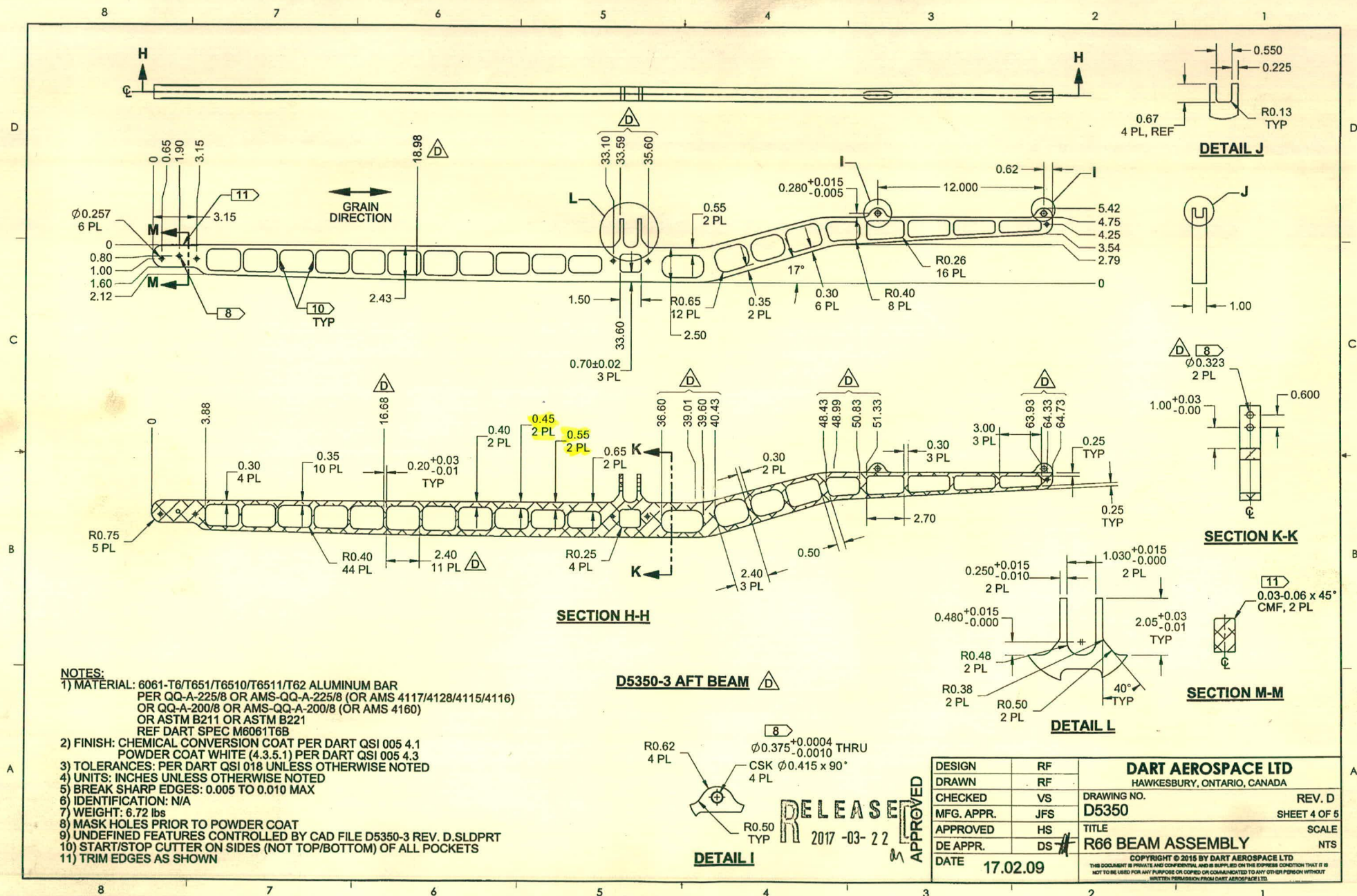
Measured by:	M.M.	Checked by:	mm	QC Inspector:	
Date:	2018/10/18	Date:	18/10/21	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	18.07.31	New Issue	KJ	

D5350-043

Job: 183641



2005003